

Date: 5/25/2007 8:37:41 AM
 User: John Johnston

Process Sheet

Split
 813 07/06/05

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32661
 Estimate Number : 12811
 P.O. Number : **NIA**
 This Issue : 5/25/2007 S.O. No. : **NIA**
 Prsht Rev. : NC
 First Issue : **NIA** Type : SMALL /MED FAB
 Previous Run : 32003
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-03.26 ec

Drawing Name : BRACKET
 Part Number : D35921
 Drawing Number : D3592 REVA
 Project Number : **NIA**
 Drawing Revision : **REVA**
 Material : **NIA**
 Due Date : 6/10/2007

UNDER REVIEW

07-06-04

OK 07/06/04

Qty: 125 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total : 17.5140 sf(s)

6061-T6 .125 Sheet

Batch: **M104366**

M104366

Grain must be Along 4.63"**

ml 070530
ml 070604

125

125

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: **#**

Prog Rev: **#**

2-Deburr if necessary

ml 070604
ml 070530

125

125

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 070604
ml 070530

125

125

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MB

07/06/05

125

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




Comment: SMALL & MEDIUM FAB RESOURCE 1

Split 07/08/23

24

Form as per Dwg D3592 using DT8949

07-07-25

| W/O: | | WORK ORDER CHANGES | | | | | | |
|---------------------|--------------|---|---------------|---------------------|---------------|---|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 07.06.05 | 2 | REPROGRAM TO REV.B TO ADD TOLLING HOLES. SEE ATTACHED DS EMAIL FOR OK ON TOLLING HOLES | | | |  07/06/05 | | |
| 07/08/08 | 5 | split w/o | SB | 07/08/08 | 24 | | | |
| 07/06/05 | 5 | split w/o | SB | 07/06/05 | 35 | | | |
| 07/01/04 | 5 | Split w/o | SB | 07/01/04 | 42 | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/08/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---------|------|---|---|--|--------------------------------------|--------------------------------|---|-------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 0706.04 | 2.0 | 125 parts scrap. parts needed extra holes for the bending tool. | <i>[Signature]</i> 07.06.04 per QS1042 | Scrap parts, and replace to Rev. B, under Preliminary Issue. See E-mail <u>Scrap: destroy parts</u> | <i>[Signature]</i> 07/06/04 SB | <i>[Signature]</i> 07/06/04 | <i>[Signature]</i> 07.06.04 per QS1042 | <i>[Signature]</i> 0706-04 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32661

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(X24) counter

Comment: INSPECT WORK TO CURRENT STEP

in 4/08/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

07.06.05

DATE

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(24)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/04

Job Completion



in 24.08.24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

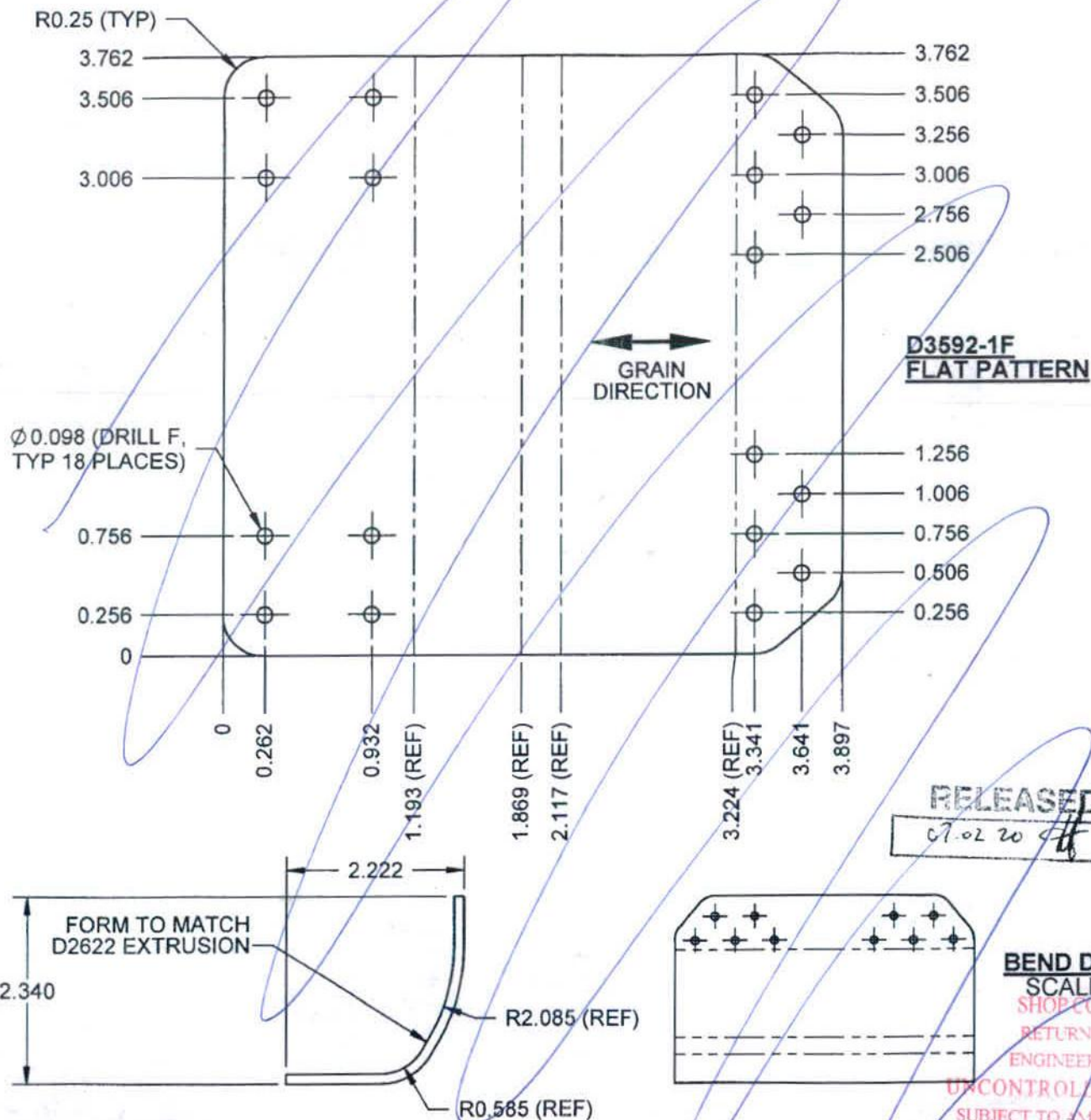
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN QP | DRAWN BY QP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3592 | REV. A SHEET 1 OF 1 |
| DATE 07.01.15 | | TITLE PLATE | SCALE 1:1 |
| A | 07.01.15 | NEW ISSUE | |



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD

Work Order: 32661

Description: Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|------------------|---------------------|--------|--------|-------------------------|----------|
| A $\phi 0.098$ | $+0.004 - 0.008$ | 0.098 | ✓ | | VERN | |
| B 3.762 | $+1 - 0.010$ | 3.768 | ✓ | | VERN | |
| C 3.897 | $+1 - 0.010$ | 3.900 | ✓ | | VERN | |
| D 0.262 | $+1 - 0.010$ | 0.264 | ✓ | | VERN | |
| E 0.932 | $+1 - 0.010$ | 0.936 | ✓ | | VERN | |
| F 3.341 | $+1 - 0.010$ | 3.348 | ✓ | | VERN | |
| G 3.641 | $+1 - 0.010$ | 3.647 | ✓ | | VERN | |
| H 0.756 | $+1 - 0.010$ | 0.759 | ✓ | | VERN | |
| I 0.256 | $+1 - 0.010$ | 0.261 | ✓ | | VERN | |
| J 3.006 | $+1 - 0.010$ | 3.011 | ✓ | | VERN | |
| K 3.506 | $+1 - 0.010$ | 3.506 | ✓ | | VERN | |
| L 1.256 | $+1 - 0.010$ | 1.256 | ✓ | | VERN | |
| M 2.506 | $+1 - 0.010$ | 2.508 | ✓ | | VERN | |
| N R0.25 | $+1 - 0.030$ | R0.25 | ✓ | | Radius Gauge | |
| O | | | | | | |
| P | | | | | | |
| Q | | | | | | |
| R | | | | | | |
| S | | | | | | |
| T | | | | | | |
| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

Measured by: ml. ml

Audited by:

Prototype Approval:

N/A

Date: 070530

Date:

Date:

N/A

Rev

Date

Change

Revised by

Approved

New Issue

KJ/RF

Jason Murdoch

From: Daniel Campbell [dcampbell@dartaero.com]

Sent: Thursday, May 31, 2007 9:41 AM

To: 'Beckett, Bill'; Bedford, Sue; 'Bell, Christopher'; Campbell, Daniel; 'Charbonneau, Eric'; 'Elsiger, Leanne'; 'Fuentes, Roberto'; Golden, Brigitte; 'Johnston, Kim'; 'Lacelle, Linda'; mbellavance@dartaero.com; 'Menard, Jean-Luc'; 'Murdoch, Jason'; phum@dartaero.com; 'Provencal, Chris'; 'Sheldon, Susanne'; 'Shepherd, David'; 'Stow, Dan'; 'Trepanier, Dale'; Willems, Sian

Subject: D3592-1 REV. A - UNDER REVIEW --

FYI,

D3592-1 is under review.

Essentially, the revision will consist of adding two 0.128 dia. tooling holes to assist in bending the part.

Bluefiles, CHG #, and in-stock items are not affected by this change.

Estimates for the D3592-1 should be placed under review.

Production is aware of this change and current production has already been modified.

Daniel Campbell

Co-op Student

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 241

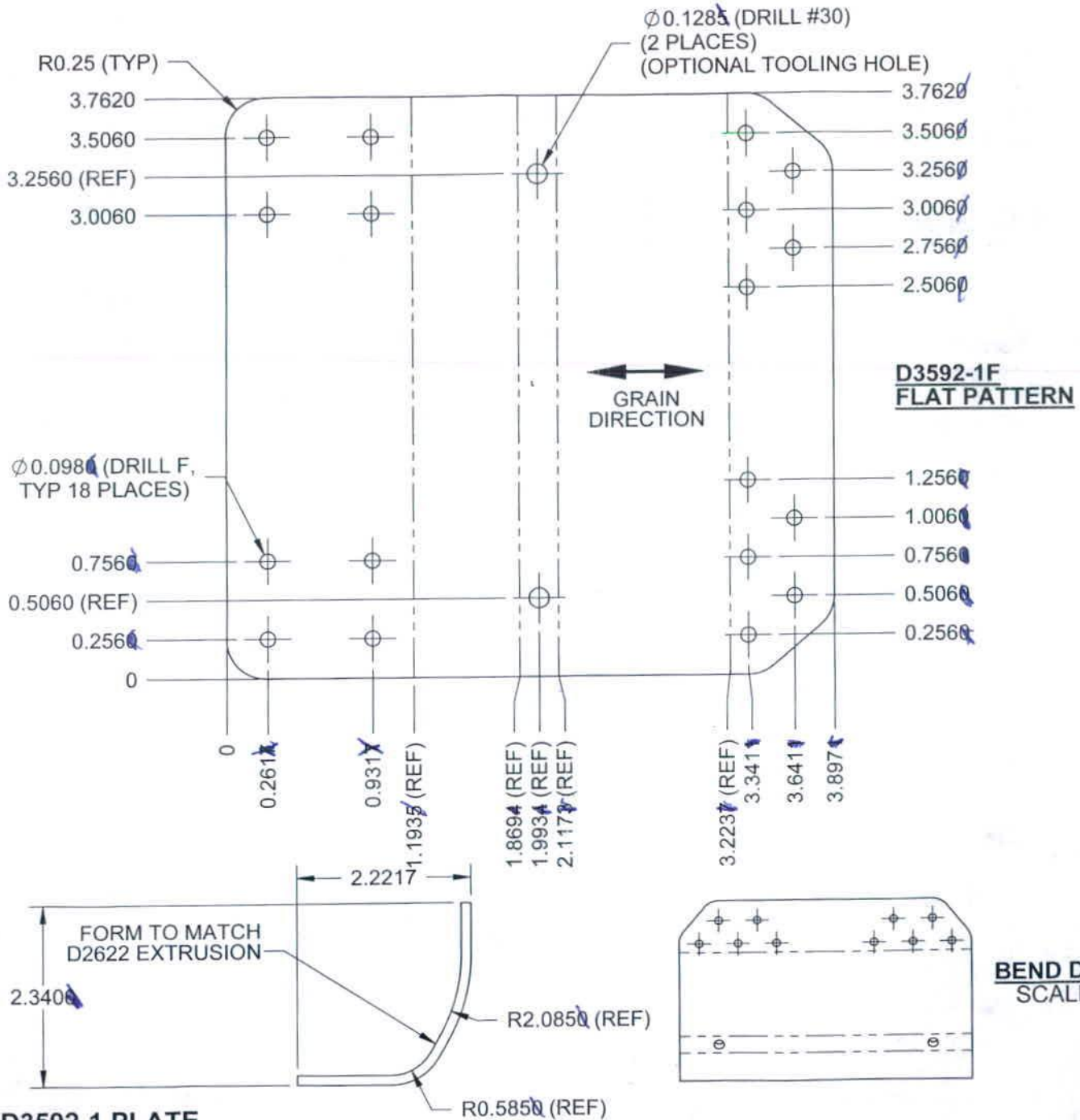
Fax: 613-632-9311

E-mail: dcampbell@dartaero.com

Web: www.dartaero.com

PRELIMINARY ISSUE
07.06.04

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN 90 | DRAWN BY JC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3592 | REV. A SHEET 1 OF 1 |
| DATE 07.01.15 | | TITLE PLATE | SCALE 1:1 |
| A | 07.01.15 | NEW ISSUE | |
| B | 07.05.31 | TOOLING HOLES ADDED | |



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 31, 2007 3:02 AM
To: 'Chris Provencal'
Subject: RE: Change on D3592-1

Yes ... this is acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, May 30, 2007 11:21 AM
To: David Shepherd (David Shepherd)
Subject: Change on D3592-1

D3592-1 Plate.

I already talked to you about this. They want to put two 0.128 dia tooling holes to assist in bending the part. Referencing the attached dwg, the holes will be placed on the flat section between the two bends (between ordinals 1.869" and 2.117"). Is this acceptable?

Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.1/822 - Release Date: 5/28/2007 11:40 AM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.1/822 - Release Date: 5/28/2007 11:40 AM

| | | |
|-----------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 32661 |
| Description: Bracket | | Part Number: D3592-1 |
| Inspection Dwg: D3592 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|--------------|---------------------|--------|--------|-------------------------|----------|
| A $\phi 0.128$ | +0.005-0.001 | 0.129 | ✓ | | VERN | |
| B $\phi 0.098$ | +0.004-0.001 | 0.099 | ✓ | | VERN | |
| C 0.506 | +/-0.010 | 0.510 | ✓ | | VERN | |
| D 0.256 | +/-0.010 | 0.260 | ✓ | | VERN | |
| E 0.756 | +/-0.010 | 0.760 | ✓ | | VERN | |
| F 3.256 | +/-0.010 | 3.260 | ✓ | | VERN | |
| G 0.261 | +/-0.010 | 0.265 | ✓ | | VERN | |
| H 1.993 | +/-0.010 | 1.995 | ✓ | | VERN | |
| I 3.341 | +/-0.010 | 3.346 | ✓ | | VERN | |
| J 3.641 | +/-0.010 | 3.645 | ✓ | | VERN | |
| K 3.897 | +/-0.010 | 3.902 | ✓ | | VERN | |
| L 3.762 | +/-0.010 | 3.766 | ✓ | | VERN | |
| M | | | | | | |
| N | | | | | | |
| O | | | | | | |
| P | | | | | | |
| Q | | | | | | |
| R | | | | | | |
| S | | | | | | |
| T | | | | | | |
| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

| | | | |
|----------------------------|-----------------------|---------------------|------------|
| Measured by: <i>mm. mm</i> | Audited by: <i>MS</i> | Prototype Approval: | N/A |
| Date: 07/06/04 | Date: 07/06/04 | Date: | N/A |
| Rev | Date | Change | Revised by |
| | | New Issue | KJ/RF |
| | | | Approved |

